Work Order ID 10 October-22-13 2:50:58 PM	8581		*108!	581*						Page 1
Item ID: D3259-3 Revision ID: Item Name: Doubler			Accept	*N900	040	100)* s	etup Start	171	S1* S2*
Start Date: 10/22/13 Required Date: 11/05/13 Reference:	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	D:		* 2 **			
Approvals: Process Pla	an: MLJ	Date: <u> 3-/0-27</u>			ate:		R	Run Start	IN	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr Rev	vision Nbr									
D3259 Rev	v B									
100 *100* Waterjet FLOW CNC Waterjet ランタリ・063	FLOW WATER JET Memo 1-Cut as per Deburr if ne	r Dwg D3259 Dwg Rev: J	0.00 B	_ 2-			8	. D		Jm13-10-2
*110 *110* QC Quality Control	QC2- Inspect parts off m	achine FAI/FAIB	0.00				8	_2		Jm3-10-26
*120 *120* OC	QC8- Inspect parts - seco	ond check	0.00 27 9-89 0.00 3 10 3	γ			8			

Quality Control

						5					DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	VFOR	MANCE / UP	DATE			
											QA Closed:	Date:	
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	- No					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
	-						」		20.80 / 22				J <u></u> J
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause	\Box	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
				<u> </u>	<u>.</u>	F	AUL	T CATE	GORY				l
Landi	ng G	ear				General					_		_
		Bending Centre No Cracks	ot Conce	ntric to	o/s	Bend BOM/Route Broken/Damaged		Grain Hardwa	are ion Incomplete		Ovalized Over/Under Part Incorre	tolerance	Pressure/Forced Temperature/Cure Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

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Work Orde		08581		*108	8581*						Page 2	
Item ID: Revision ID: Item Name:	D3259-3 Doubler			Accept	*N900	<u>040</u>	100)* ፡	Setup Star	ı	S1* S2*	
Start Date: Required Date: Reference:	10/22/13 11/05/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	D:						
Approvals:		an:		Tooling: SPC (Y/N):		ate:		1	Run Star Sto	" \	R1* R2*	
Sequence ID/ Work Center II 130 *120* Small Fab	D	Operation Description Small Fab Memo		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp () 1	DA 36 9-8
Small Fab 140 *140 *next * Brake NC Brake NC		NC BRAKE Memo	oles as per Dwg D3259 Dwg D3259	0.00				7				ાવે 3
150 *150* QC		QC5- Inspect part compl		0.00 DAS 0.00 27 9-89 0.00 /3 /0	. 3 U			7		Pho	.	

Quality Control

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DOA: Sul Date: 13/11/22

										QA Closea:	The Date.	19/1/12
Work Order:	108	358	1		DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	\mathfrak{D}_3		-3		Rework Scrap Use-as-is Work Order Update		N Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	l	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	į.	itial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator				Csi	M was done	9	DAS 1 6 -89	Scrap	a destroy		DAS 27 9-89	DAS 16 9-89
Other	13/10/29	(30	1	R(1 000	the whong Able chator Didni Read so convey /Loa	1311	2012 11115	Non Poor	a destroy uplace reforly	13/430	13.1030	13/11/15
Supplier Training Unapproved					LOX			\$4.5	17			972042
						AULT	CATE	GORY				
Landing	Gear				General							
	Bending Centre No	ot Conce	ntric to	o/s	Bend BOM/Route	\vdash	Grain Iardwa	re		Ovalized Over/Under	tolerance	Pressure/Forced Temperature/Cure
	Cracks				Broken/Damaged	∐ir	nspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	<u> </u>	nstruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	Ш١	√lainte	nance		Part Moved		
	Heat Trea	it		Ø.	Countersink	∟ا	∕Iislabe	led		Positioned V		- /
	Inspectio	•	Tube	<u> </u>	Cut Too Short	Ш^	∕lisread	I _		Power Loss/	Surge L	Other
	Ripples in				Drill Holes	Щ	Offset			_ c.si	1 k more	hole
	Torque W			n L	Drawing	Щс	Out of C	Calibration			<u> </u>	
1 L	Turning S	•		L	Finish		Out of S	Sequence				
	Wave/Tw	ist in Tul	эе		Folio		Outside	Dimensions				

Page 3

Work Order ID 108581 October-22-13 2:50:58 PM Item ID: D3259-3 Accept *N900040100* **Revision ID:** Item Name: Doubler Start Qty: 8.00 **Start Date:** 10/22/13 **Cust Item ID:** Required Date: 11/05/13 Req'd Qty: 8.00 **Customer:** Reference: Process Plan: Date: _____ Tooling: Approvals: Date: Date: QC: SPC (Y/N): Date: Sequence ID/ Tool ID Operation Tool # Plan Set Up/ **Work Center ID Description Run Hours** Code 160 Chemical Conversion Coat per QSI005 4.1 0.00 *160* HandFinish 0.00 Memo Hand Finishing

7 1613-11-11

Reject

Number

Insp.

Stamp

Setup Start

Stop

Start

Stop

Reject

Qty

Run

Accept

Qty

170 *170* QC

Quality Control

Memo

QC3- Inspect Part Finish

0.00

DAS 0.00 **27** 9-89

1311.11

180

Identify as per dwg & Stock Location:

180

Packaging Packaging

Memo

0.00

DAS

13-11-11.

											DQA:	Date	e: _	
NCR: Y	es /	No				WORK ORDER NON-C	ON	NFORM	AANCE / UPI		QA Closed:	Date	<u>-</u> م	
Work Orde	er:					DISPOSITION				AGAINST DE			<u> </u>	
Part N						Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	i	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update	l	nitial	Act	tion	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification		QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
_							AUL	T CATE	SORY					
Landi	Ce Cr Cr Cu	ending entre No racks rushed/C uffs eat Treat spection	Crimped t		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		1	ion Incomplete ions Incomplete/U enance eled		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	$\boldsymbol{\vdash}$	pples in	-			Drill Holes		Offset		L	•	- L		

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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Work Orde				*108	3581*		Annual II II Annual Ann					Page	4
Item ID: Revision ID: Item Name:	D3259-3 Doubler			Accept	*N900	040	100)*	Setup	Start .		S1* S2*	
Start Date: Required Date: Reference:	10/22/13 11/05/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	D:							
Approvals:	Process Pl	lan:	Date:	Tooling: SPC (Y/N):		ite:			Run	Start Stop		R1* R2*	
Sequence ID/ Work Center II	D	Operation Description QC21- Final Inspection	· Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt	y N	Reject Number 3/11/1	Insp. Stamp	

0.00

Memo

QC

Quality Control

mf 13/1/11

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	CONFOR	MANCE / UP	DATE	QA Closed:	 Date:	
Work Orde					DISPOSITION		<u> </u>	AGAINST DE			
Part N					Rework Scrap Use-as-is	4 1	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	o			 	Work Order Update]	Large Fab	Composite]	Supplier	
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data			ł								
Equip/Tooling					,						·
Operator											,
Material											
Setup											
Other							:		ļ		
Process											ļ
Supplier		ŀ									
Training		İ									
Unapproved											
					<u> </u>	AULT CATE	GORY				
Landin	ng Gear				General				_		-
	Bending				Bend	Grain			Ovalized		Pressure/Forced
· [Centre No	ot Conce	ntric to	o/s	BOM/Route	Hardwa	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspect	ion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	Instruct	tions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
[Cuffs				Contamination	Mainte	enance		Part Moved		
	Heat Trea	at			Countersink	Mislabe	eled		Positioned V	Vrong	_
	Inspectio	n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes	Offset			_		

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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Page 1

Work Order ID: 108581

108581

Parent Item:

D3259-3

D3259-3

Parent Item Name: Doubler

Start Date: 10/22/13

Required Date: 11/05/13

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A New Issue 07-07-19 JLM

Verified By:EC

IPP REV

B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	- •	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	336.0789	1.388	(12)			
M2024T3	RS 063								**			Jm	3-10-20

"I/I/U/4	1.55	Uh.3"
2024-T3 .063 sheet		

Location	Loc Qty	Loc Code	
MAT022	336.0789		
119916	0.2		
121197	21.34		
123096	11.4		
123654	11.64		-
123701	16.1039		
125341	87.94		
125636	187.455		125636

NCR: Y	'eś	/ No				WORK ORDER NON-C	ONFOR	MANCE / UP	DATE	DQA:	Date:	, •
		,								QA Closed:	Date:	
Work Orde	er: _				<u> </u>	DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS Water Jet	Fasiassias
Part N	lo					Rework Scrap Use-as-is		Skid-tube Machining moforming	Crosstube Small Fab Finishing	ł	d. Eng. Coor.	Engineering Quality Other
NCR N	No					Work Order Update		Large Fab	Composite		Supplier	
Root					Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	•	Date	Step	Qty	. (or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data					1							
Equip/Tooling						•						
Operator		:				·						
Material					-							
Setup			1									
Other								1				
Process												
Supplier												

FAULT CATEGORY Landing Gear General Ovalized Pressure/Forced Bend Grain Bending Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Broken/Damaged Weld Cracks Inspection Incomplete Part Incorrect Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Positioned Wrong Heat Treat Countersink Mislabeled Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Misread Drill Holes Ripples in Bend Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Out of Sequence Finish Folio Outside Dimensions Wave/Twist in Tube

Training Unapproved

DART AEROSPACE LTD	Work Order:	108581
Description: Doubler	Part Number:	D3259-3/-4
Inspection Dwg: D3259 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.000	+/-0.005	9.003	_		V	Productor
1.000	+/-0.005	1.001	_		V	Themas
0.260	+/-0.010	©:362	_		ν	
R0.25	+/-0.030	0.25	_		RG	
R0.50	+/-0.030	0.50"	_		Rb	
5.000	+/-0.005	5.003			V	
0.875	+/-0.005	0.878"	_		ν	
12.000	+/-0.005	13.003,	_		V	
3.500	+/-0.005	3.501			٧	
0.875	+/-0.005	0.876"	_		V	
R0.13	+/-0.030	0.13"	_		Rb	
0.500	+/-0.005	0.203,	_		V	
0.525	+/-0.005	0.5a7	_		٧	
1.80	+/-0.030	1.809	_		V	
Ø0.128	+0.005/-0.000	0.194,			V	
Ø0.377	+0.005/-0.000	0.378"	_		V	
Ø0.098	+0.005/-0.000	0.099	_		V	
0.063 thick	+/-0.005	0.063	_		V	
Grain Direction	N/A		_			
-						

Measured by: Jm Audited by: 27 Preliminary Approval:

Date: 13-10-36 Date: 13 10 28 Date:

Rev	Date	Change	Revised by	Approved
Α	04.08.25	New Issue P/O D412-705-019	KJ/JLM	
В	10.06.07	Dwg Rev updated	KJ L	1.1
С	10.08.03	Dimensions updated	KJ 981	
			1/1	7-4

											DQA:	Date:	
NCR:	es ,	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UPDA				
											QA Closed:	Date:	
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	 No					Scrap Machining Sr Use-as-is Thermoforming F Work Order Update Large Fab Cor			Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					Descri	ption of work order update		Initial	Action	n į	Sign &		,
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Descript	tion	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUI	LT CATE	GORY				
Landi	$\overline{}$				r	General	_	-			I		7 .
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs				o/s	Bend BOM/Route Broken/Damaged Burrs Contamination	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance			Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	
	Heat Treat Countersink							Mislabe	eled		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

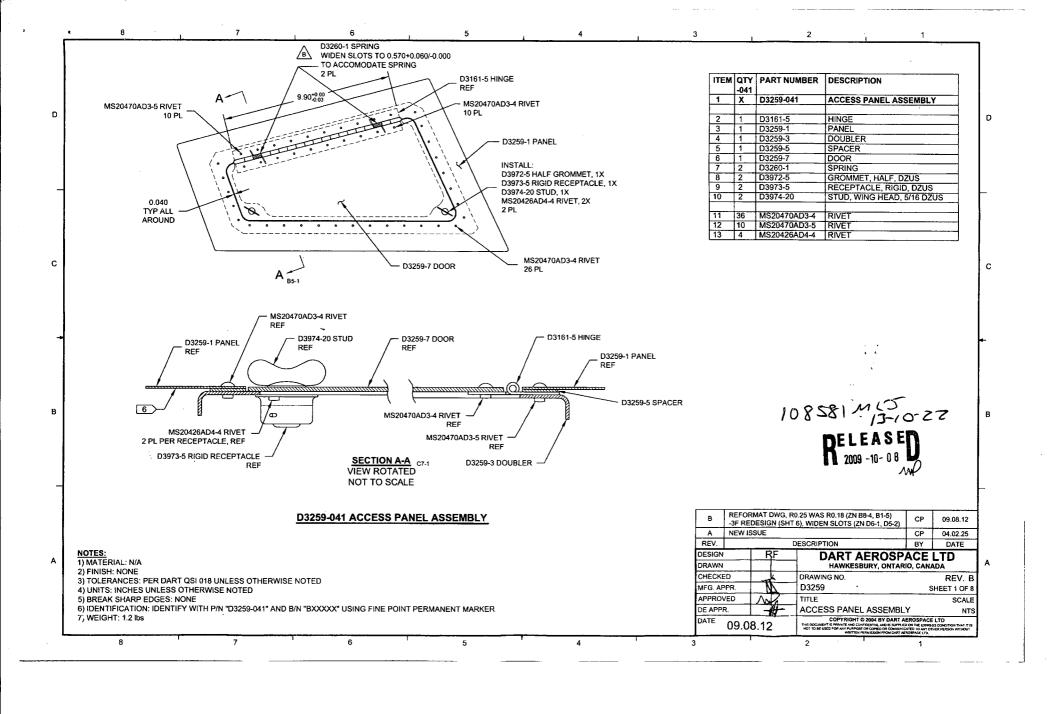
Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



												DQA:	Da	ate:	
NCR: Y	es /	/ No				WORK ORDER NON-O		NFORM	AANCE / UP	DATE					
												QA Closed:	Da	ate:	
Work Orde				,		DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
WOIK OIGE	- · ·					Rework	1		Skid-tube	Crosstube	٦		Water Jet		Engineering
Part N	No.					Scrap	1]		Machining	Small Fab	┨	Pro	d. Eng. Coor.	-	Quality
	_					Use-as-is	1 1	ł .	noforming	Finishing			e/Packaging	\vdash	Other
NCR I	No		· .	·		Work Order Update]		Large Fab	Composite			Supplier	·	
Root					Descri	ption of work order update		nitial	Act	tion	٦	Sign &		1	
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	n	QC Inspector
Doc/Data															
Equip/Tooling															
Operator	Ш										Ì				
Material	Ш									•				ļ	
Setup															
Other							İ								
Process	Ш														
Supplier							1								
Training	Ш				•										
Unapproved			<u> </u>												
						F	AUL	T CATE	GORY						
Landi	ng Ge	ear				General	_					•		_	
	ШВ	ending				Bend		Grain				Ovalized			Pressure/Forced
						BOM/Route	L	Hardwa	re			Over/Under	tolerance		Temperature/Cure
	Cracks					Broken/Damaged		Inspecti	on Incomplete			Part Incorred	ct	L	Weld
	Crushed/Crimped					Burrs		4	ions Incomplete/	Unclear		Part Lost/Mi	ssing	L	Wrong Stock Pulled
-	Cuffs					Contamination		Mainte	nance			Part Moved			
	<u></u> ⊢	leat Trea	it		L	Countersink		Mislabe	led			Positioned V	Vrong	_	
		nspection	n Strip in	Tube		Cut Too Short	Misread			Power Loss/	Surge		Other		
	I R	Ripples in	Bend			Drill Holes	Offset								

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

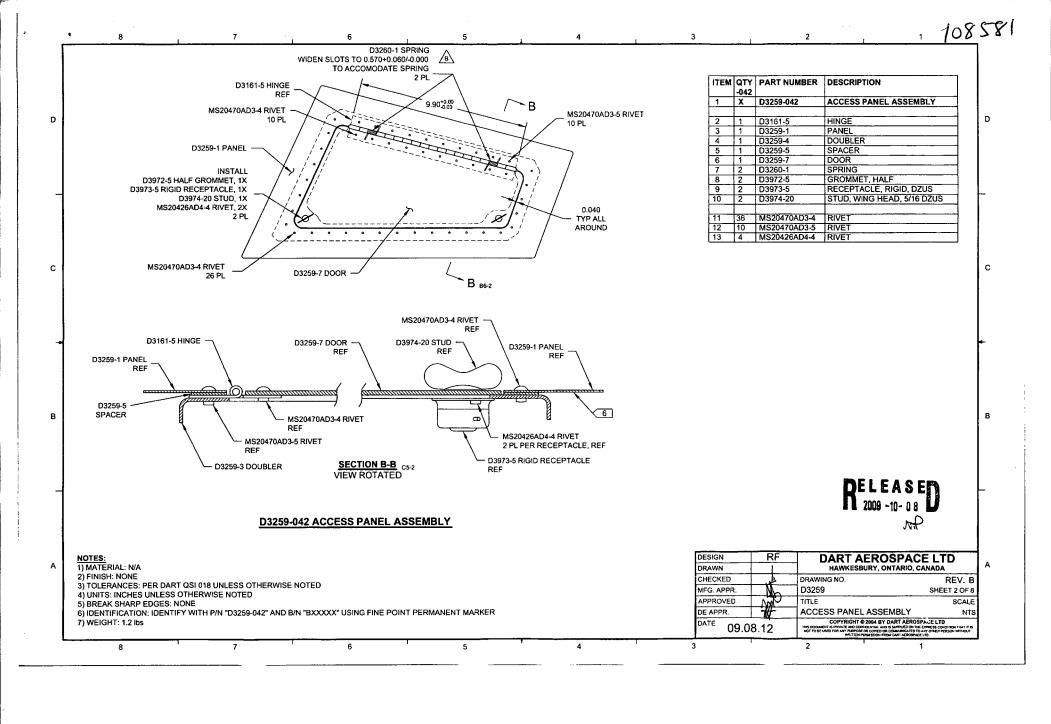
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	ON	IFORN	ANCE / UP	DATE		_	
					· · · · · · · · · · · · · · · · · · ·					QA Closed:	Date:	
Work Orde	r.				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N					Rework Scrap		ľ	Skid-tube Machining	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor.	Engineering Quality Other
NCR N	lo				Use-as-is Work Order Update			oforming Large Fab	Composite	Rec/stor	Supplier	Other
Root				Descri	ption of work order update	li	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling											į	
Operator												
Material								i				
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Other			}									
Process												
Supplier												
Training												
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Landir	ng Gear			·	General		ı			7	_	7
	Bending				Bend	Ш	Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	O/S	BOM/Route	Ш	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks			-	Broken/Damaged	-	-	on Incomplete		Part Incorred	⊢	Weld
	Crushed/	Crimped		<u></u>	Burrs	\vdash		ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
Cuffs				ļ	Contamination	Ш	Mainte	nance		Part Moved		
Heat Treat				<u> </u>	Countersink	-	Mislabe			Positioned V		7
	Inspectio	-	Tube		Cut Too Short	\vdash	Misread	İ		Power Loss/	Surge	Other
	Ripples in	n Bend		L	Drill Holes		Offset					
	Torque V	Vaves in E	Extrusio	n	Drawing		Out of O	Calibration				

Out of Sequence

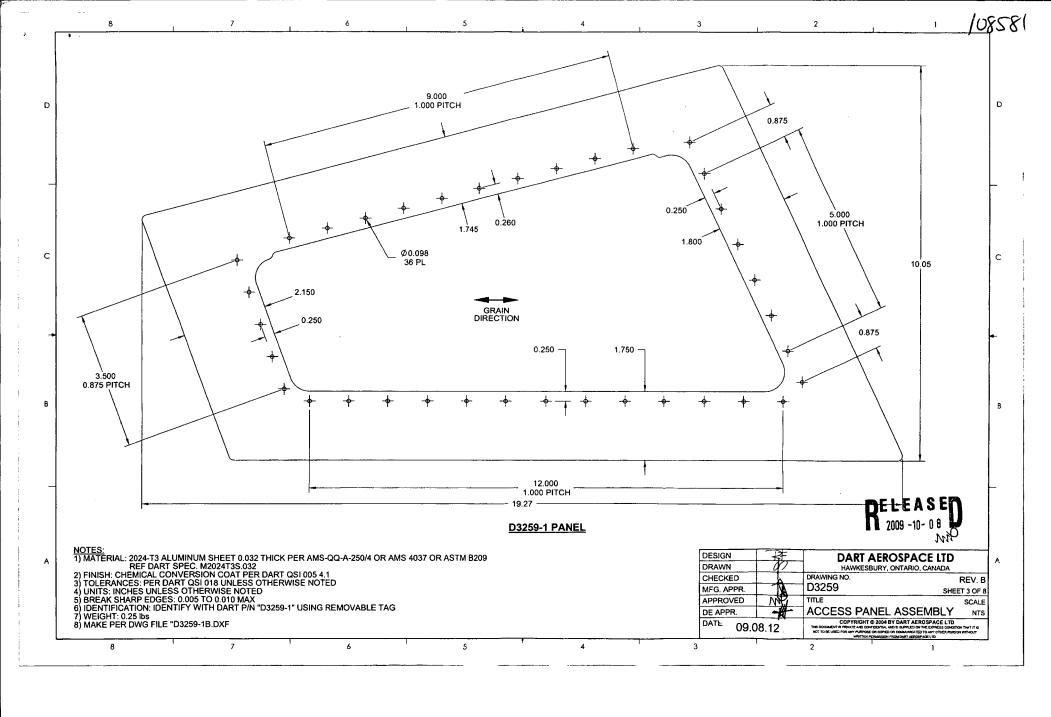
Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



											DQA:	Date:	
NCR: Y	es /	No				WORK ORDER NON-O	CON	FORM	MANCE / UP	DATE			
											QA Closed:	Date:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIR OIGC	-1		.			Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is]	Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	No					Work Order Update			Large Fab	Composite		Supplier	
								i			c: o		
Root			C4	04.		ption of work order update	1	nitial		ction	Sign &	Varification	OC Inchestor
Cause	_ '	ate	Step	Qty	•	or Non-conformance	Cni	ef Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data	<u> </u>											:	
Equip/Tooling		ŀ											
Operator	Ц.				:								
Material													
Setup							İ						
Other									-				
Process								:					
Supplier				:			1						
Training												,	
Unapproved				ĺ									
						F	AUL	CATE	GORY				
Landi	ng Gear	7		·		General							
	Ber	nding				Bend		Grain			Ovalized		Pressure/Forced

Broken/Damaged Weld Cracks Inspection Incomplete Part Incorrect Crushed/Crimped Burrs Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Cuffs Contamination Part Moved Maintenance Countersink Mislabeled Heat Treat Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Drill Holes Ripples in Bend Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Folio Wave/Twist in Tube Outside Dimensions

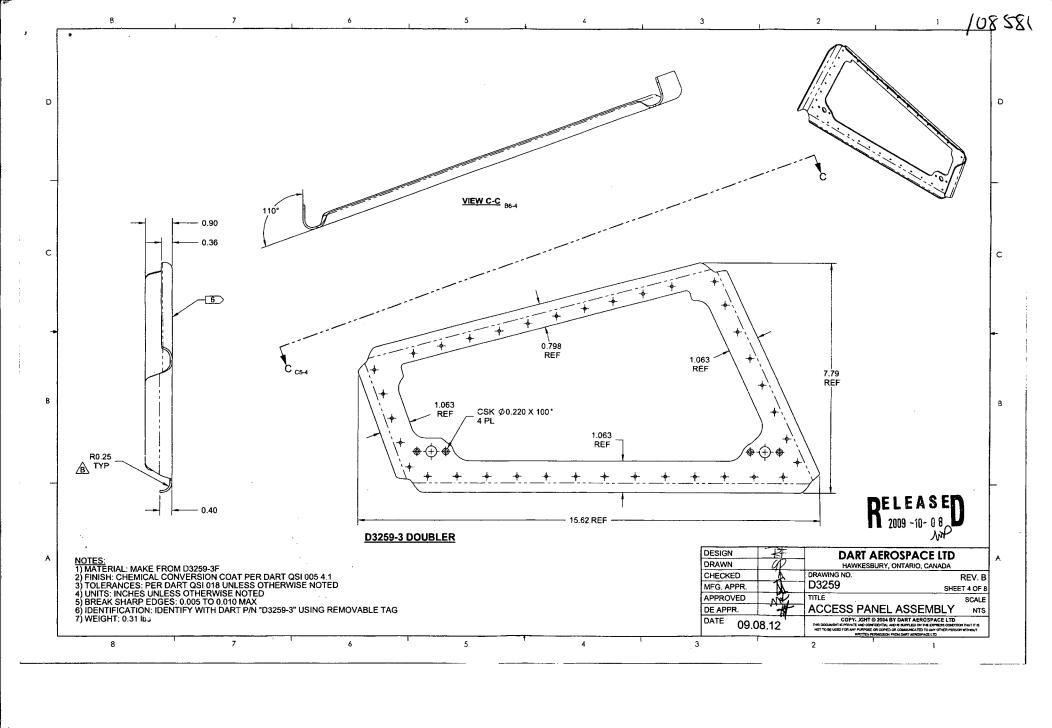
Hardware

Over/Under tolerance

Temperature/Cure

Centre Not Concentric to O/S

BOM/Route



										DQA:	uate:	
NCR: Y	es ,	/ No				WORK ORDER NON-C	ONFO	RMANCE / UF	PDATE	QA Closed:	Date:	
Work Orde	er:					DISPOSITION			AGAINST DE			
Part N	– - ا	•				Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining rmoforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Initial	A	ction	Sign &		
Cause	Ì	Date	Step	Qty	(or Non-conformance	Chief En	g Des	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other												
Process Supplier	Н]					
Training	Н		l i									
Unapproved	П											
				.	·	F	AULT CAT	EGORY				
Landi	ng Ge	ear				General					<u></u>	_
		Bending				Bend	Grain	1		Ovalized		Pressure/Forced
	Centre Not Concentric to O/S					BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
	Cracks					Broken/Damaged	—	ction Incomplete		Part Incorre	-	Weld
	Crushed/Crimped					Burrs	-	ictions Incomplete	/Unclear	Part Lost/M		Wrong Stock Pulled
	Щ	Cuffs				Contamination	\vdash	tenance		Part Moved		
	Ш۲	leat Trea	it		L	Countersink	Misla	beled		Positioned V		-
	l li	nspectio	n Strip in	Tube		Cut Too Short	Misre	ad		Power Loss/	'Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

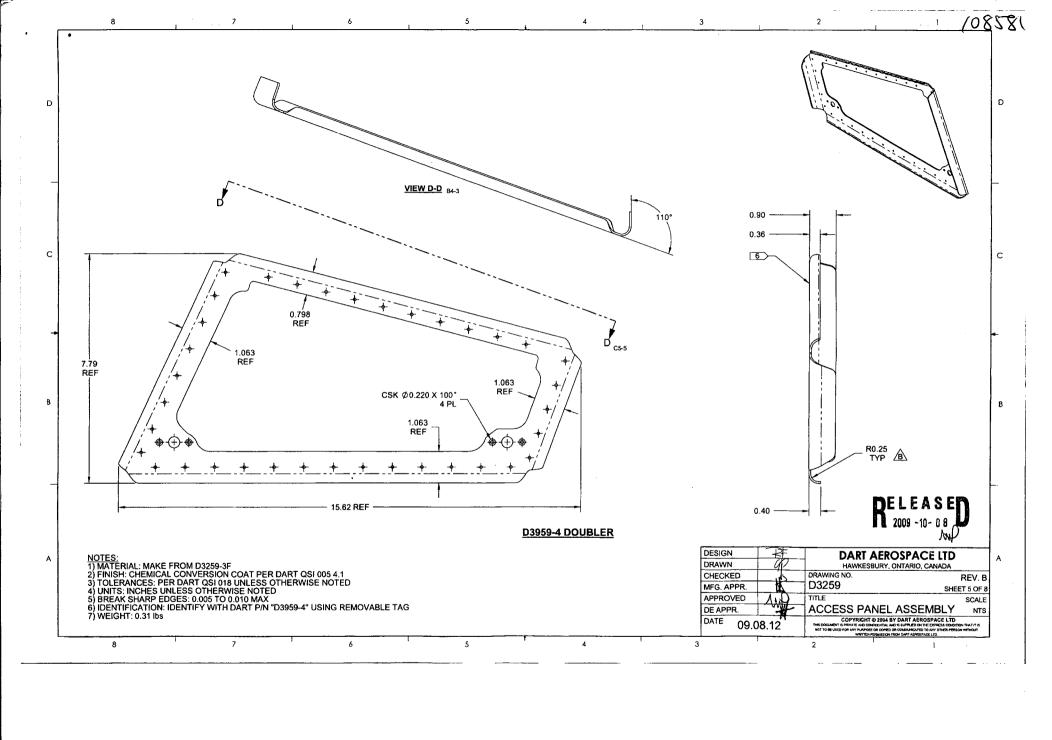
Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish



NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
5 .											QA Closed:	Date	:
Work Ord	er:					DISPOSITION				AGAINST DI	EPARTMENT	<u></u>	
Part I	•					Scrap Machining Small Fa Use-as-is Thermoforming Finishir Work Order Update Large Fab Composit				Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Ti	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved					,			T CATE	CORV				
Land	ina (General	AUI	LICATE	GORT				
Carlo	Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/l nance led	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
1	L	I rorque v	vaves III I	LAU 0510	· L		L_	Jour or C	שמוטוו מנוטוו				

Out of Sequence

Outside Dimensions

DQA:

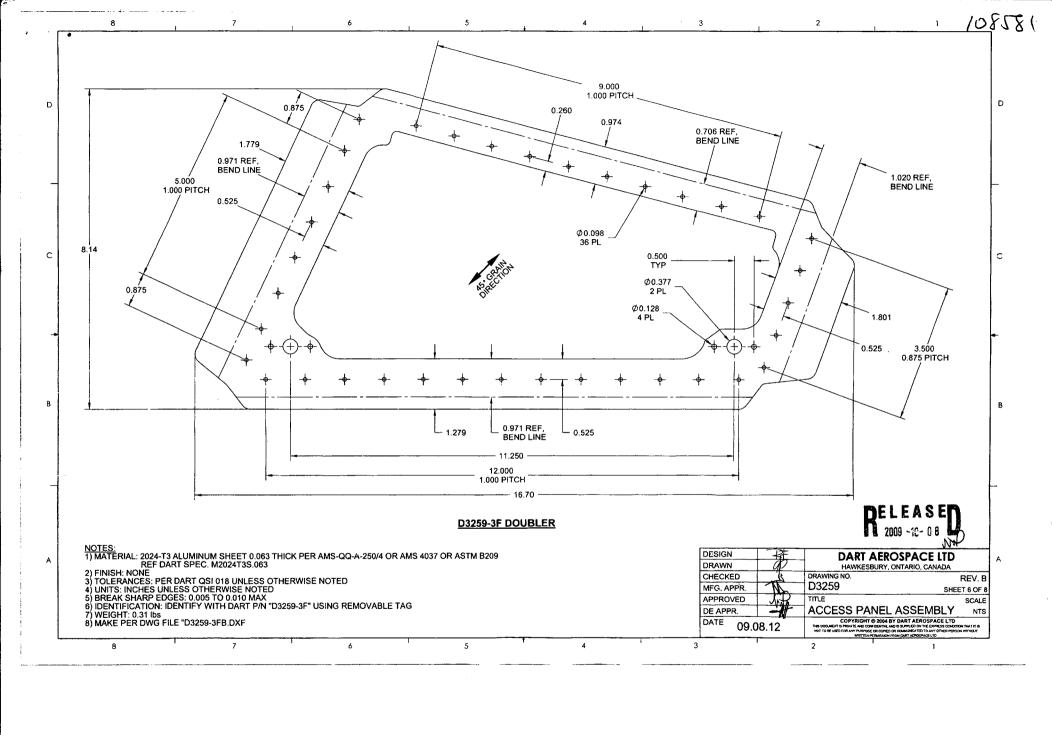
Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

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										DQA:	Date	:
NCR:	res / No				WORK ORDER NON-	COI	NFORM	AANCE / UPDATE				
										QA Closed:	Date	•
Work Orde	ar.				DISPOSITION			AGAIN	ST DE	PARTMENT	PROCESS	
WOIK OIGE					Rework	٦		Skid-tube Crosstu	he	1	Water Jet	Engineering
Part N	No.				Scrap	1		Machining Small F		Pro	d. Eng. Coor.	Quality
		····			Use-as-is	1	l	noforming Finish	-	i	e/Packaging	Other
NCR I	No.				Work Order Update	1	8	Large Fab Compos	ite	1	Supplier	1
,						_				-		
Root				l .	iption of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup	Ш											
Other	Ш											
Process	Ц			ļ								
Supplier				1		1					:	
Training			ļ	1								
Unapproved	<u> </u>		<u>.</u>				T CATE	CODY				
1 1		<u></u>				AUI	LT CATE	GURY				
Landi	ing Gear				General Bend	Г	Grain			Ovalized	Г	Pressure/Forced
	Bending			0/5	BOM/Route	-	4	***	\vdash	Over/Under	toloranco	Temperature/Cure
Centre Not Concentric to O/S				-	-	Hardwa		\vdash	Part Incorred	ļ	Weld	
Cracks				Broken/Damaged	\vdash	-l `	ion Incomplete	-	Part Incorred	<u> </u>	Wrong Stock Pulled	
	Crushed/Crimped				Burrs	Instructions Incomplete/Unclear			- 1	ILAL FOST/INI	22111R	I WHO II SLOCK PUHED
	Cuffs	•			Contamination	\vdash	Mainte	· ·		Part Moved	_	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

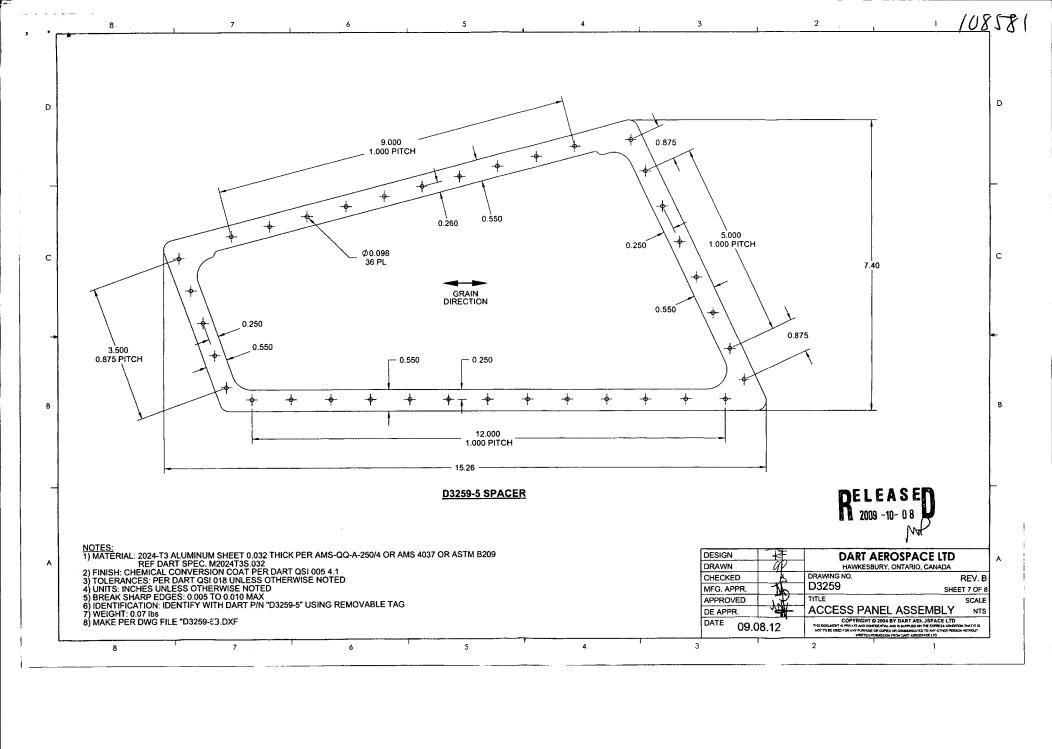
Cut Too Short

Drill Holes

Drawing

Finish

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												DQA:	Da	te:	
NCR:	/es	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE					
												QA Closed:	Dat	te:	
Work Orde	sř.					DISPOSITION				AGAINST [ЭΕI	PARTMENT	PROCESS		
Work Orac	-''-					Rework	1		Skid-tube	Crosstube	\neg		Water Jet	Г	Engineering
Part N	No.					Scrap	1		Machining	Small Fab	\Box	Prod	d. Eng. Coor.		Quality
	•					Use-as-is]	Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR I	۷o. ِ		<u>.</u>			Work Order Update]		Large Fab	Composite			Supplier	<u></u>	
Root	_		<u> </u>	ı –	Descri	ption of work order update	T	nitial	Δς	tion	_	Sign &			
Cause		Date	Step	Qty	1	or Non-conformance		ief Eng		ription		Date	Verification	n	QC Inspector
Doc/Data				~.,							\dashv			_	1
Equip/Tooling									i						
Operator											ł				
Material											ļ				
Setup															
Other			į.												
Process											1				
Supplier									-		ļ				
Training															
Unapproved	·														
						F	AUI	T CATE	GORY		_				
Landi	ng (Gear				General		-		_		-	ı		
		Bending				Bend		Grain		L		Ovalized		L	Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance	L	Temperature/Cure
		Cracks				Broken/Damaged	L	Inspect	on Incomplete			Part Incorred	:t	L	Weld
	Crushed/Crimped Burrs							Instruct	ions Incomplete/	'Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

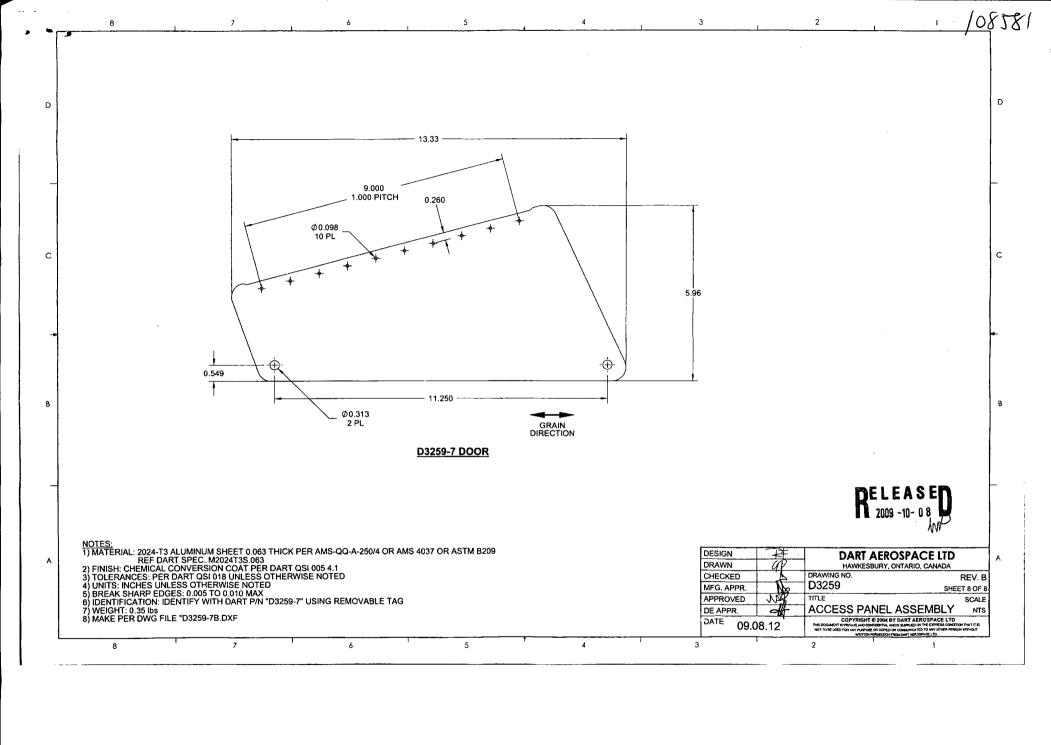
Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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		-									* *
,	1 31								DQA:	Date:	
NCR: Ye	s / No				WORK ORDER NON-C	ONFOR	MANCE / UP	DATE	QA Closed:	Date:	
Work Order	•			<u>-</u>	DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No).				Rework Scrap		Skid-tube Machining	Crosstube Small Fab	1	Water Jet d. Eng. Coor.	Engineering Quality Other
NCR No	D				Use-as-is Work Order Update	Ineri	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling						į					
Operator								4			
Material										ļ	
Setup		1									
Other				,							
Process				Ď.							
Supplier				Į.							

FAULT CATEGORY .											
Landing	Gear	General									
	Bending	Bend		Grain		Ovalized		Pressure/Forced			
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure			
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld			
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled			
	Cuffs	Contamination		Maintenance		Part Moved		_			
	Heat Treat	Countersink		Mislabeled		Positioned Wrong		_			
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge		Other			
	Ripples in Bend	Drill Holes		Offset			-				
	Torque Waves in Extrusion	Drawing		Out of Calibration							
	Turning Sequence	Finish		Out of Sequence							
	Wave/Twist in Tube	Folio		Outside Dimensions							

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Training Unapproved